

Date: Wednesday, 3/26/2008 9:50:27 AM
 User: Kim Johnston

Process Sheet

15

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HELI UTILITY BASKET
 Job Number : 38156
 Estimate Number : 10854
 P.O. Number :
 This Issue : 3/26/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D350721041
 First Issue : 1 / 1 Type : LARGE FAB ASSY Drawing Number : N/A
 Previous Run : 38046 Drawing Revision : N/A
 Material :
 Due Date : 4/11/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : JD 08.3.26
 Comment : Est Rev:D as per Rev B 05-11-21 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D350-721-041CHG002

08/04/14 08/04/11 JLD

2.0 38156A BASKET LID ASSEMBLY



Comment: Sub-Component BASKET LID ASSEMBLY

D3325-041 B 38156 A

ml 08/04/14

3.0 38156B BASKET BASE ASSEMBLY



Comment: Sub-Component BASKET BASE ASSEMBLY

D3324-041 B 38156 B

ml 08/04/14

4.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick: Assembly Kit

5.0 D2022101 Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2022-101

Spacer 33988

AS 08/04/11

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2332041

Lid Prop Assembly 6.69"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

1 D2332-041

prop arm

310849

JS 08/04/11 (X)

7.0

D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle Weldment

Batch:

37456

JS 08/04/11 (X)

8.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

2 D2535

Spring

36397

JS 08/04/11 (X)

9.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

2 D2537

Bushing

36893

JS 08/04/11 (X)

10.0

D2931

Bumper



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

2 D2931

Bumper

21139

JS 08/04/11 (X)

11.0

D3320041

Webbing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

1 D3320-041

Webbing

38258

JS 08/04/11 (X)

Dart Aerospace Ltd

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Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D33511

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 D3351-1

Label

34755

AS 08/04/11

(X)

13.0

AN316A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN3-16A

Bolt

M106815

AS 08/04/11

(X)

14.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN4-7A

Bolt

M102140

AS 08/04/11

(X)

15.0

AN420A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 AN4-20A

Bolt

M106895

AS 08/04/11

(X)

16.0

AN422A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 AN4-22A

Bolt

M104937

AS 08/04/11

(X)

17.0

AN517A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN5-17A

Bolt

M107242

AS 08/04/11

(X)

W/O:		WORK ORDER CHANGES					
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QA: N/C Closed: _____ Date: _____

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Job Number: 38156

Part Number: D350721041

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN960JD416

Washer

M100780

AS 08/04/11 (X)

19.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN960JD416L

Washer

M107008

AS 08/04/11 (X)

20.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN960JD516

Washer

M107008

AS 08/04/11 (X)

21.0

AN960JD8

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN960JD8

Washer

M107091

AS 08/04/11 (X)

22.0

AN960JD9

Washer



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

32 AN960JD9

Washer

M105399

AS 08/04/11 (X)

23.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN970-4

Washer

M107042

AS 08/04/11 (X)

Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 38156

Part Number: D350721041

Job Number:



Seq. #:

Machine Or Operation:

Description:

24.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 32.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

32 MS20600AD4W3 Rivet

18071

JS 08/04/11 (X)

25.0

MS20600AD4W2

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 MS20600AD4W2 Rivet

4747

JS 08/04/11 (X)

26.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 MS21042L3

Nut (or -3)

M106883

JS 08/04/11 (X)

27.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 MS21042L4

Nut (or -4)

M106825

JS 08/04/11 (X)

28.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 MS21042L5

Nut (or -5)

M106785

JS 08/04/11 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 38156

Part Number: D350721041

Job Number:



Seq. #:

Machine Or Operation:

Description:

29.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



(P10) →

Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg IIN-D350-721 Attach Travelers:

Seal rivet Holes with Sika Flex before riveting

A/R 291 Sika Flex

Batch:

M105585

Exp Date:

10/2008

ml 08/04/14 x1

30.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/14 (40)

31.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

32.0

D22301

Mounting Lug



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

3 D2230-1

Lug

36747

AS 08/04/11 (X)

33.0

D22303

Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 D2230-3

Clamp

37152

AS 08/04/11 (X)

34.0

D2856400

Abrasion Strip



Comment: Qty.: 2.5200 f(s)/Unit Total: 2.5200 f(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 D2856-4007.20"

Abrasion Strip

36161

AS 08/04/11 (X)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-721-041 PAR #: _____ Fault Category: Prod / FAB ASS" mod & small NCR: Yes No DQA: D Date: 08/24/16
 QA: N/C Closed: D Date: 08/04/16

NCR: <u>38156</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/04/14	29.	During inspection it was found that the two rivets for the Bumpers were ground with a counter sink.	<u>[Signature]</u>	Remove Both Rivets and Replace. Put sikoplex in two holes	<u>[Signature]</u> 08/04/14	<u>[Signature]</u> 08/04/14	<u>[Signature]</u>	<u>[Signature]</u>
		QC employee used a Die grinder not a file.	<u>[Signature]</u>	Scrap Washers and Bumper too. Replace New one 3 Rivets MS 20600 AD4W2 M107 3 Bumper D2931 B21132 3 Washers AN 960 JD8 M107091	<u>[Signature]</u> 08/04/14	<u>[Signature]</u> 08/04/14	<u>[Signature]</u>	<u>[Signature]</u>

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Job Number: 38156

Part Number: D350721041

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

D33381

Mounting Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3338-1

Lug

33248

JS 08/04/11 (X)

36.0

D3350041

Strut Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D3350-041

Strut

36248

JS 08/04/11 (X)

37.0

AN412A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 AN4-12A

Bolt

M105143

JS 08/04/11 (X)

38.0

AN413A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

8 AN4-13A

Bolt

M106993

JS 08/04/11 (X)

39.0

AN414A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 AN4-14A

Bolt

M105653

JS 08/04/11 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: HELI UTILITY BASKET

Job Number: 38156

Part Number: D350721041

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

AN960JD416

Washer



Comment: Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

28 AN960JD416

Washer

M106780

AS 08/04/11 (Y)

41.0

MS21042L4

Nut



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

18 MS21042L4

Nut (or -4)

M106825

AS 08/04/11 (X)

42.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/04/11 (X)

43.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-721-041

Location: 38156A

PPP Rev: Rev C

AS 08/04/11 (X)

44.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/11 (X)

Job Completion



mf 08-04-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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